

Date: Friday, 12/21/2007 7:27:09 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 36508	
Estimate Number : 10267	
P.O. Number :	Part Number : D2438
This Issue : 12/21/2007 S.O. No. :	Drawing Number : D2438 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 36027	Material :
Written By :	Due Date : 1/20/2008 Qty: 200 Um: Each
Checked & Approved By : <u>07.12.21</u>	
Comment : Est: E 05.06.28 Bending removed KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5336

Laser cut as per Dwg D2438

Material release note is required

07/12/21 (200)

2.0	D2438B	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)
CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

08/01/21 (200)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438
(6.786" center to center)

08/01/21

(200)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr any rough edges

08/01/23 (200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PD Date: 08/02/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/21/2007 7:27:09 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 36508

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



08/01/31



Comment: INSPECT WORK TO CURRENT STEP

08/01/30 8200

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 456

8/1/31 50 200x

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2000
08/02/01

Job Completion



08/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

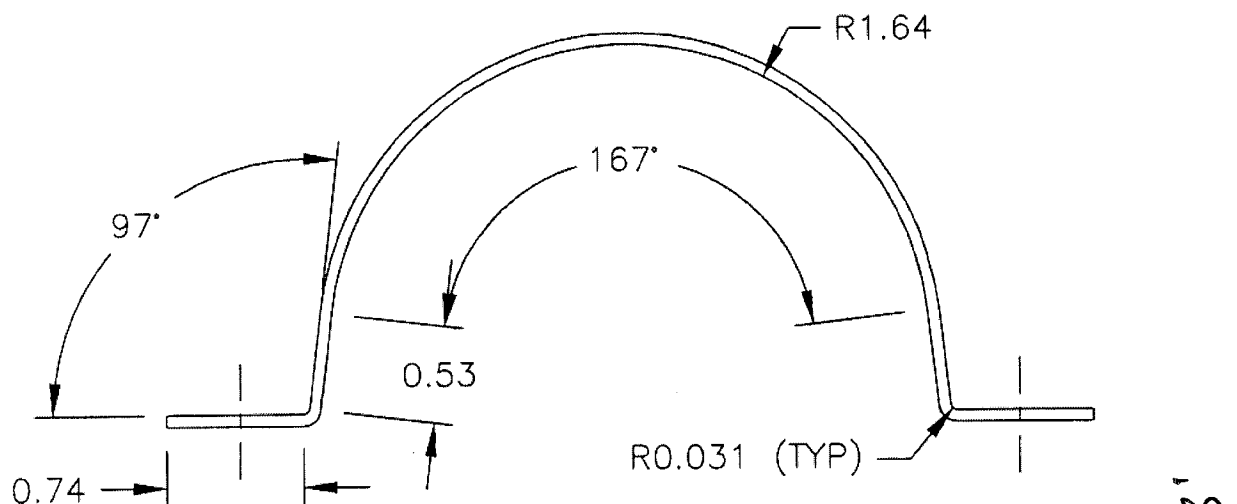
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

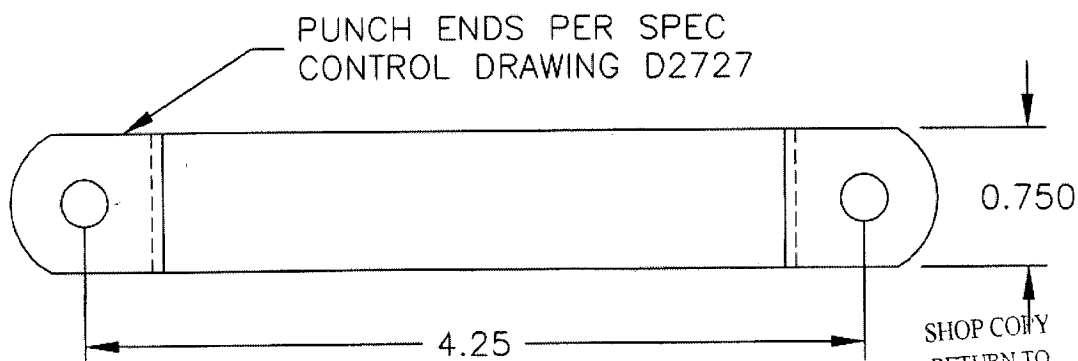


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
48.06.17 KE



3.983



3.984

FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **36508**

00.06.06
CP 00.06.07



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VI VENDU À / SOLD TO



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/01/17	0383091

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIPMENT
DART GFI-0299		J0174204	PO00005336	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.		DESCRIPTION	
200	D2438B		CLAMP CUT&FORMED C OF C REQ'D	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 13 OUR JOB NO J0174204 SHIPPING MEMO 0383091

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	<u>200 PCS</u>	<u>PO00005336</u>	<u>D2438B</u>	<u>C</u>	<u>CLAMP</u>	<u>C</u>
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
<u>S.S.T 304</u>		<u>TW METALS / NORTH AMERICAN</u>			<u>2MW9</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 17 JANUARY 2008

G.F.I. Q.C. REP.

Daltan



859-07

DP12-001 REV. 6 Bombardier Certificate of Compliance
TW Metals District Procedure

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME: GFIPURCHASE ORDER No. 0072661ITEM No. 0001SHIPPER INVOICE No. 03227600MATERIAL: 304-2BSPECIFICATION: ASTM A262MANUFACTURING MILL: North American StainlessSIZE: 062HEAT / LOT No. 2MW9PART No. F506348K964AQUANTITY: 3 EA.TEST DEPARTMENT CLERK: Janice Clark

AUTHORITY

Joe Schab

Director of Quality Assurance

This document is maintained as a Controlled Document only in the TW Metals computer system. Once printed, this document immediately becomes Uncontrolled and is subject to change at any time and without notice.

FERGUSON METALS, INC.

36 X 56
P.O. 49180040
Sales: 01098014
QTY: 2

Size: 304/L ANN. 1060-1064 AMS5513
Customer: TW METALS INC.
Heat: 2HW9
Shipped: 09/04/07 10617

Authorized Signature

This is to certify that in accordance with the records in our files the material shipped on you purchase order conforms to the following.

3475 Symmes Road

Harrison, OH 45013

Brad Butler



NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 365147 02

Mail To:

FERGUSON METALS INC.
3475 SYMMES ROAD
HAMILTON, OH 45013

Ship To:

FERGUSON METALS INC.
3475 SYMMES ROAD
HAMILTON, OH 45013

Customer: 0018 001

Date: 7/11/2007 Page: 1

Steel: 304/304/304L

Your Order: 01010133

NAS Order: AN 0273673 01

Finish: 2B

Corrosion: ASTM A262/02a; 1808end-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/06D, 480/06D, 666/03, ASME A240/04-A05, 480/04-A05, SA666/04
Q08766D-AXMG PRM, AMS5511B/5513B/5516P, AMU3, 2 CRWN WEAS

REMARKS:

Mat'l Free of Mercury Contamination. No weld repairs.
EN 10204 3.1; Q08763F Cond A; RoHS Compliant
* Melted & Manufactured in the USA

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
022MW9 A	* 022MW9 A	.0620	36.0000	20,700 COIL	2778.9	11	1	

CHEMICAL ANALYSIS

CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa)

Heat	CM	C	CR	CU	EN	MO	N	NI	P	S	SI
2MW9	US	.025	18.329	.298	1.832	.311	.072	8.113	.026	< .001	.332

MECHANICAL PROPERTIES

Product ID #	Coil #	Id of CF	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard	Grain No.
022MW9 A	022MW9	F T	95.50	48.52	48.03	86.50	82.50	8.000

TW METALS

TEST

SEP 14 2007

ACCEPTED BY

REVIEWED BY Q.C.

Date 7/13/07 by [Signature]

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

7/11/2007